

Date: Tuesday, 08/01/2008 10:47:28 AM  
 User: Jean-Luc Menard

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLATE
<b>Job Number</b> : 35874	
<b>Estimate Number</b> : 10499	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D320411
<b>This Issue</b> : 08/01/2008 <b>S.O. No.</b> : NA	<b>Drawing Number</b> : D3204 REV. A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 19/11/2007 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 32839	<b>Material</b> : N/A
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 03/12/2007
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Comment</b> : Est:C 05.08.11 Added Step 25 KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0375X01000	6061T6 BAR
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1.5000



**Comment:** Qty.: 0.1116 f(s)/Unit Total : 0.8929 f(s)  
 M6061-T6 BAR .375"X 1.00"  
 Batch: 104598 IB 8-1-8

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3204  
 Dwg Rev: A1  
 Prog Rev: A1

IB 8-18

13

2-Deburr if necessary IB -8-1-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-8

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 1-Mill to .300" as per Dwg D3204

2-Open hole to .191" as per Dwg D3204

3-Deburr

080114

13

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 35874

Part Number: D320411

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JA* 08/01/14

13

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 08/01/14

13

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Francis*

*08/01/14* (13)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/01/15* (13)

Job Completion



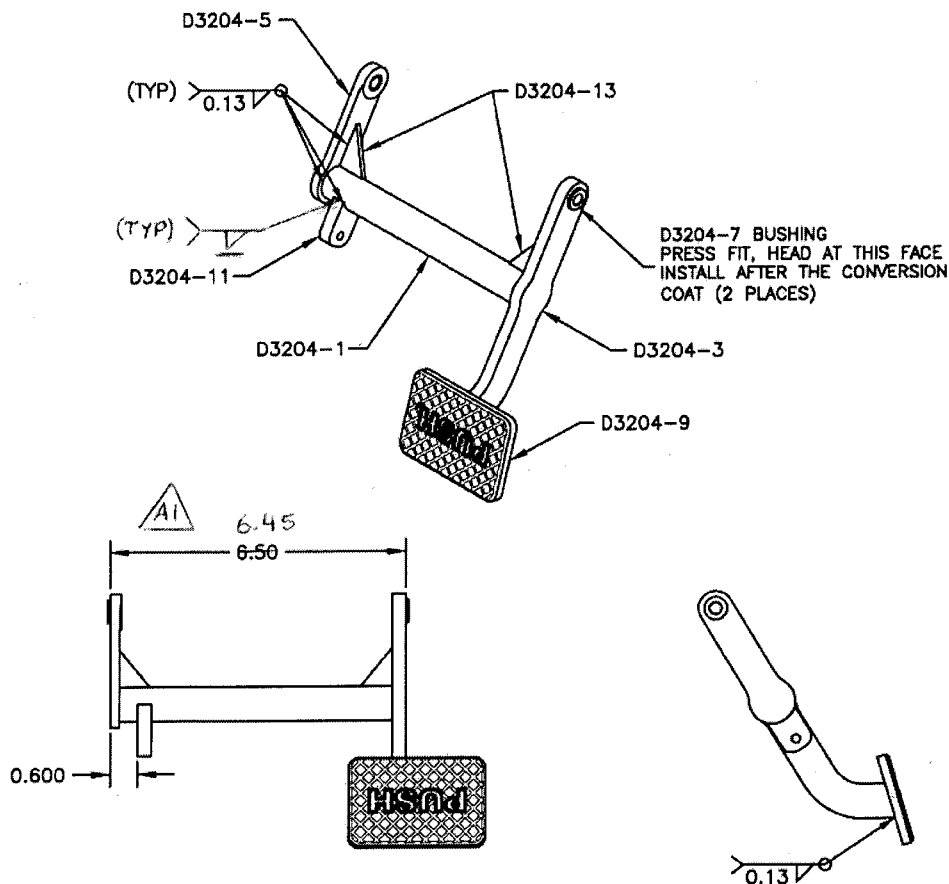
*08/01/15*





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CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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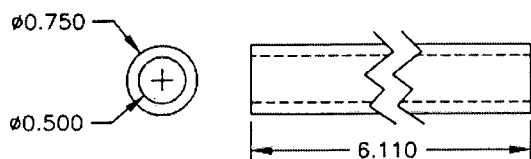
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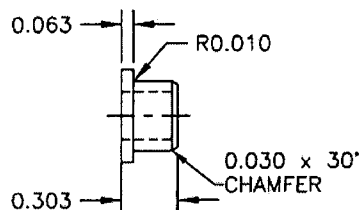


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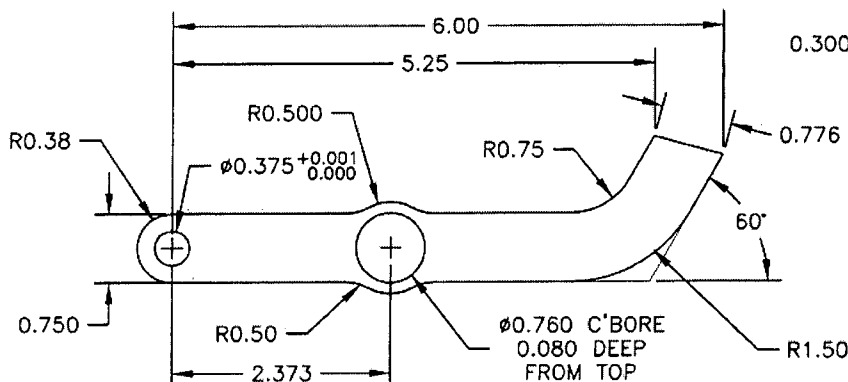
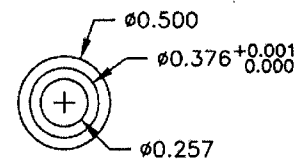
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04.04.05 #



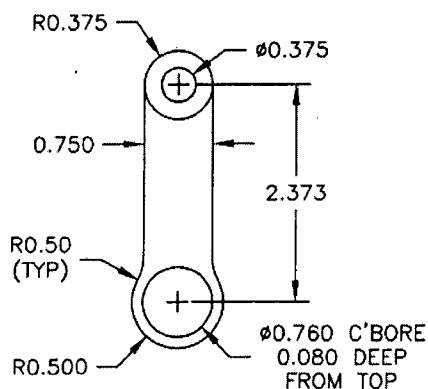
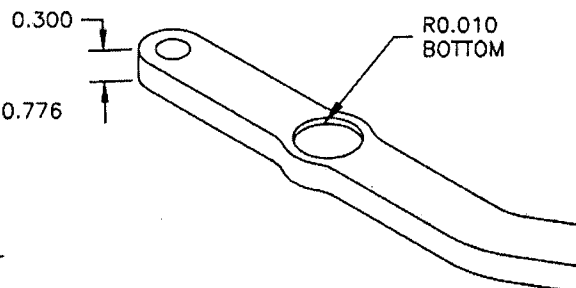
2 D3204-1 TUBE  
SCALE 1:2



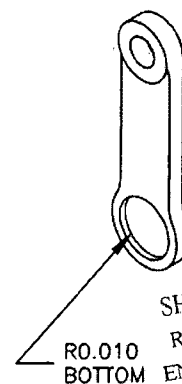
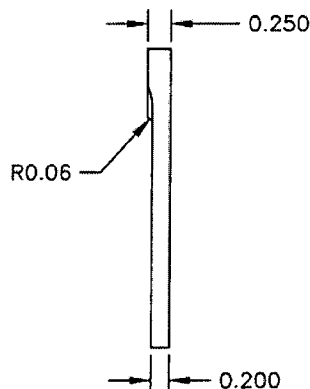
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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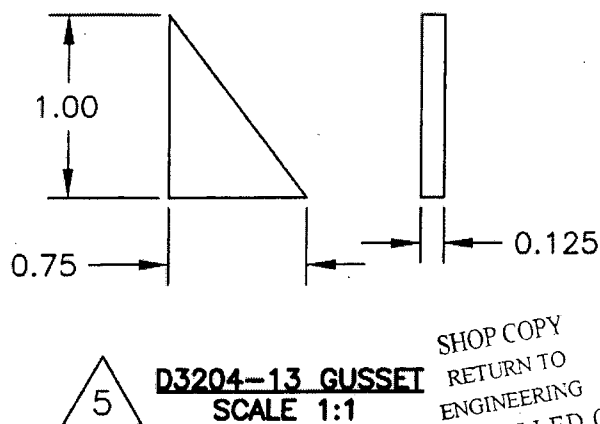
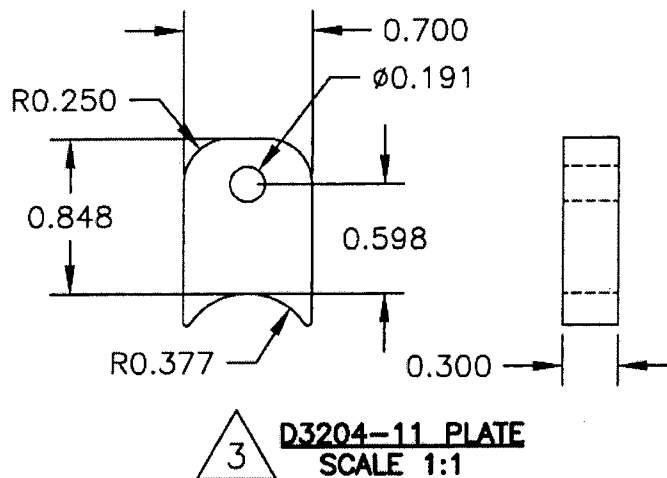
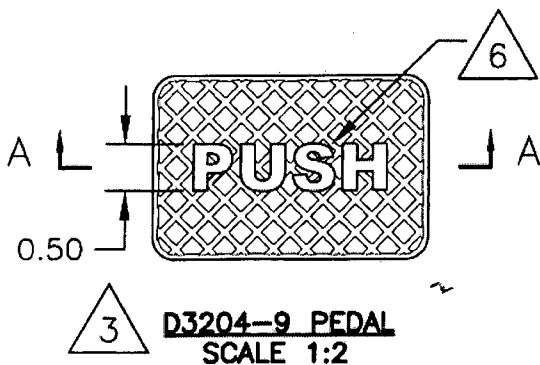
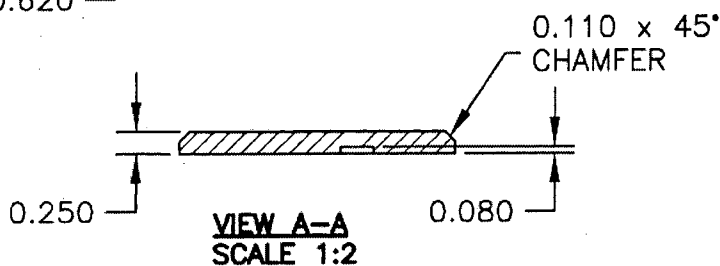
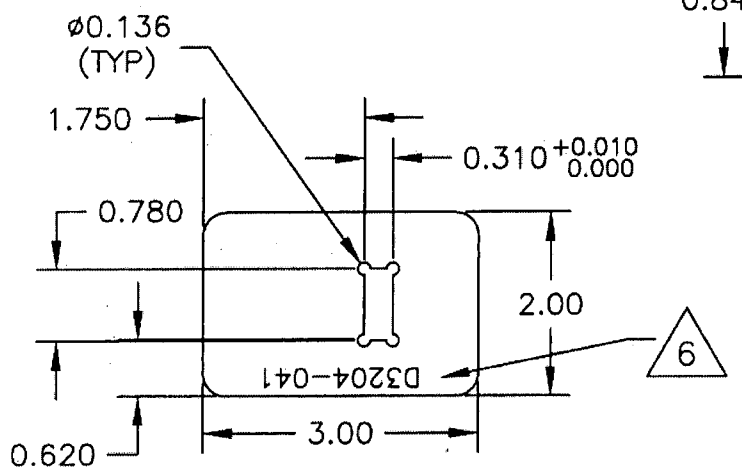
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